

Date: Wednesday, 3/8/2006 10:44:26 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PLACARD
Job Number	: 26148		
Estimate Number	: 11149		
P.O. Number	: N/A	Part Number	: D32141
This Issue	: 3/8/2006 S.O. No. : N/A	Drawing Number	: D3214 REVA1
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: A1
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 3/20/2006 Qty: 10 Um: Each
Checked & Approved By	: 06.03.08		
Comment	: Est. A04.04.15 New issue KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S080	5052-H32 .080 Sheet
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Comment: Qty.: 0.0780 sf(s)/Unit Total : 0.7802 sf(s)  
 5052-H32 .080 Sheet  
 Material: 5052-H32/H34 (QQ-A-250/8) 0.080" thick  
 (M5052H32S.080)  
 Identify for D3214-1  
 Batch: M19729

SB 06/03/09 (10)

2.0	SHEAR	SHEAR
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Comment: SHEAR  
 Cut blanks: 3.70" x 2.70"  
 Drill hole and fillet corner as per Dwg D3214  
 Deburr  
 Identify as D3214-1

SB 06/03/10 (10)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

06.03.10 (10)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

SAH 06.03.14 (10)

5.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING  
 Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/04/01 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/06  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: PLACARD

Job Number: 26148

Part Number: D32141

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FC 06 04 03 10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Engrave text as per Folio FA394 and Dwg D3214

J.F./J.L 06-04-03 10

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 06-04-04 10

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.G. 06/04/04 10

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 416

CE 4/4/5 (10)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/04/06 (10)

Job Completion



W 06/04/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED TF	APPROVED TF	DRAWING NO. D3214	REV. A SHEET 1 OF 1
DATE 04.01.27		TITLE PLACARD	SCALE 1:1
A	04.01.27	NEW ISSUE	
AI	04.05.14	CORRECT TYPO: 4.3 WAS 4.1	

RELEASED  
04.04.05



D3214-1

NOTES

- 1) MATERIAL: 5052-H32 /H34 (QQ-A-250/8) 0.080 THICK (M5052H32S1080) COPY
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.1
- 3) ENGRAVE LETTERS (0.50" HEIGHT) AS SHOWN AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE

WORK ORDER  
NO. 26148

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